

Work Order ID 75427

75427

Page 1

Friday, October 21, 2011 2:24:01 PM

Item ID: D206-642-151 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube
 Start Date: 10/21/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/2/2011 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: P Date: 11-10-21 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3804	A								
IIN-D206-642	O								

100

0.00

100

DOCUMENT CONTROL

DC

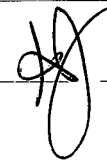
Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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1

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M117889

4-Grind weld flush to cap on top surface only

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804 .

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

*B u/u/25**BE 11-11-25**B u/u/25**AL u/u/28*

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing 0.00

120

QC

Memo 0.00

Quality Control

De
11/11/28

11. 11. 28 (1)

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

① u/u/28

1 0 BRU-11-29

u/u/29

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC6- Inspect dimensions to drawing	0.00							
170						<u>1</u>	<u>0</u>	<u>BE11-11-29</u>	
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Skidtubes	0.00							<u>DL</u>
Skidtubes	Memo								<u>11/11/29</u>
Skidtubes	1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required								
	2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting								
	Start Date: <u>11/11/29</u> Time: <u>11:00 am</u>								
	Finish Date: _____ Time: _____								
	Pick:								
	Qty Part Number Description Batch								
	A/RSikaflex-291 <u>119399</u>								
	Sikaflex expire date: <u>12/08/13</u>								

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Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 0 BEH-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Skidtubes	0.00							
200									
Skidtubes	Memo	0.00							
Skidtubes	1-remove alodine from around hole and prepare for welding								
	2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.								
	Pick:								
	QtyPart NumberDescriptionBatch								
	A/RAluminum Rod <u>M117889</u>								
	3-Grind welds flush as per Dwg D3804.								
	4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.								
	A/RSS Rod <u>NONE</u>								
	5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr								

Pl 11/11/30

BE 11-11-30
 BU 11/30

DP 11-12-1

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Customer:




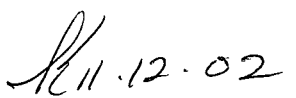

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
210									
HandFinish	Memo	0.00							
Hand Finishing	Install D2680-041 Nut Plate as per Dwg D3804								
				11-12-1					
215	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
215									
QC	Memo	0.00							
Quality Control				11.12.01		1			
220	QC10- Inspect visual per QSI004- ground welds	0.00							
220									
QC	Memo	0.00							
Quality Control				11.12.02		1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NS1

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NS2

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1

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1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

11-12-02

240

Pressure Wash per QSI005 4.3

0.00

240

HandFinish

Memo

0.00

Hand Finishing

1 11-12-05

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

250

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-40 0.00 OF
320
9-10

1 X of m-f 11/12/06

m 118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

CH

1 BL 11-12-8

1 BL 11-12-8

W/O:		WORK ORDER CHANGES					
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280	HandFinishing	0.00							
280	HandFinish	0.00				1		BL 11-12-9.	
Hand Finishing	Memo 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 <u>119-443</u> Sikaflex expire date: <u>12-1</u> 2- Install wearplate as per dwg 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: <u>118988</u>								
290	QC3- Inspect Part Finish	0.00							
290	QC	0.00							
Quality Control	Memo								

Left

50112609

W/O:		WORK ORDER CHANGES					
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300	QC5- Inspect part completeness to step on W/O	0.00							
300									
QC	Memo	0.00							
Quality Control									
310		0.00							
310	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-151								
	Location: _____								
	PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

Switzer

PP 75699

11/12/10

11/12/13

11/11/2.09

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured

No

110

Each

13.0000

1

**

(1)

BE 11/11/25 X

D2620

Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG

75469

13

71646

3

71617

6

73783

1

73785

1

73786

2

D2647

Manufactured

No

110

Each

197.0000

1

1

**

BE 11-11-25

D2647

Cap

Location

Loc Qty

Loc Code

LG002

197

55352

4

71171

10

73826

183

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part.No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 21, 2011 2:24:07 PM

Work Order ID: 75427

75427

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

18,861.00

52

52

CR3212-4-04

Cherry Rivet

**

Dh
11/11/29

Location

Loc Qty

Loc Code

ST311

150

116471

78

117816

3

118686

1

118840

68

st510

10000

119075

10000

ST516

8711

119017

8711

52

D2654-1

Manufactured

No

180

Each

3.0000

1

1

D2654-1

Web

**

Dh
11/11/29

Location

Loc Qty

Loc Code

LG

75429

3

73794

3

1

D3286-1

Manufactured

No

180

Each

108.0000

2

2

D3286-1

Doubler

**

Dh
11/11/29

Location

Loc Qty

Loc Code

LG002

108

74111

20

74441

88

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Page 3

Friday, October 21, 2011 2:24:07 PM

Work Order ID: 75427

75427

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No

200 Each 1,146.000 19 19

D2649

Cross Bolt Spacer

**

BE 11-11-30
B73859 *19

Location	Loc Qty	Loc Code
LG	617	
68224	2	
71355	2	
72704	2	
72841	11	
73855	600	
LG001	529	
65317	1	
68507	11	
73390	8	
73857	21	
73860	488	

D3286-3 Manufactured No

200 Each 97.0000 2 2

D3286-3

Spacer

**

BE 11-12-01
B74870 *2

Location	Loc Qty	Loc Code
LG001	97	
74117	17	
74439	80	

D2680-041 Manufactured No

210 Each 99.0000 1 1

D2680-041

Nut Plate

**

DP 11-12-1

Location	Loc Qty	Loc Code
LG	4	
73334	4	
ST020	95	
73854	95	

Friday, October 21, 2011 2:24:07 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 4

Friday, October 21, 2011 2:24:07 PM

Work Order ID: 75427

75427

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

210

Each

2,010.000

2

2

CR3212-4-03

Cherry Rivet

**

DP 11-12-1

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1008

114859

1008

ST318

1000

119017

1000

AN960JD416

NAS1149D0463J

Purchased

No

210

Each

0.0000

1

1

AN960JD416

Washer

**

118384 BR 11-12-9

CCR264SS3-3

Purchased

No

210

Each

1,285.000

2

2

CCR264SS3-3

Cherry Rivet

**

DP 11-12-1

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

283

117849

283

ST317

1000

119017

1000

MS27039-4-06

Purchased

No

210

Each

433.0000

1

MS27039-4-06

Screw

**

BR 11-13-9

Location

Loc Qty

Loc Code

ST292

433

119075

400

119124

33

Friday, October 21, 2011 2:24:07 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 21, 2011 2:24:07 PM

Work Order ID: 75427

75427

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No

270 Each 1,063.000 6 6

D2651-1

Plug

**

BR 11-12-9

Location	Loc Qty	Loc Code
fpa	2	
69018	2	
FP-A	1061	
57869	1	
66445	10	
70839	2	
71037	31	
73827 ✓	1017	

D2651-3 Manufactured No

270 Each 1,547.000 6 6

D2651-3

O-Ring

**

BR 11-12-9.

Location	Loc Qty	Loc Code
FP-A	1547	
61962	12	
66956	30	
73489 ✓	505	
73828	1000	

D3873-1 Manufactured No

280 Each 342.0000 14 14

D3873-1

Bushing

**

BR 11-12-9.

Location	Loc Qty	Loc Code
ST088 <i>73832</i>	342	
64760	1	
68247	4	
73829	19	
73831	318	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, October 21, 2011 2:24:08 PM

Work Order ID: 75427

75427

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280

Each

91.0000

1

1

D2646

Aft Cap

**

BR 11-12-9.

Location

Loc Qty

Loc Code

FP002

73825
73294

60

60

FP004

68280

17

17

FP006

62678

5

5

FP-4

70945

5

1

71070

4

fp5

71038

4

4

D3805-041

Manufactured No

280

Each

0.0000

1

1

D3805-041

Wearplate Assembly Fwd, Low Gear

MS27039-1-08

Purchased No

280

Each

1,971.000

2

2

MS27039-1-08

Screw

**

1 BR 11-12-8

**

BR 11-12-9

Location

Loc Qty

Loc Code

ST291

117423

1971

155

118378 ✓

316

118910

500

119075

500

119109

500

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Friday, October 21, 2011 2:24:08 PM

Work Order ID: 75427

75427

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

280

Each

9,976.000

7

7

MS21042L3

Nut

**

BR 11-12-9

Location

Loc Qty

Loc Code

ST300

976

117441

16

117885

87

118451

179

118927 ✓

694

ST516

6000

119017

6000

ST518

3000

119075 ✓

3000

D3805-045

Manufactured

No

280

Each

5.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

1 BR 11-12-8.

Location

Loc Qty

Loc Code

FP

5

73817

5

AN960JD10L

NAS1149D0332J ✓

Purchased

No

280

Each

0.0000

2

2

AN960JD10L

Washer

**

2 BR 11-12-8.

Friday, October 21, 2011 2:24:08 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, October 21, 2011 2:24:08 PM

Work Order ID: 75427

75427

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No

280 Each 2,319.000 7 7

AN3-37A

Bolt

**

BR 11-12-09

Location	Loc Qty	Loc Code
ST353	269	
111668	169	
118628	100	
ST354	50	
117619	50	
ST518	2000	
119086 ✓	2000	

7

NAS1149D0363J Purchased No

280 Each 2,836.000 7 7

NAS1149D0363.J

Washer

**

BR 11-12-09

Location	Loc Qty	Loc Code
ST298	2836	
117601	218	
118077	135	
118612	483	
118968 ✓	2000	

7

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-180	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 95427

11-10-21

RELEASED

09.03.03
PC E2N 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	99		
DRAWN	99		
CHECKED	99		
MFG. APPR.	99		
APPROVED	99		
DE APPR.	99		
DATE	08.07.07		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3804	SHEET 1 OF 5
TITLE	SCALE
SKIDTUBE ASSEMBLY, 206A/B	NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

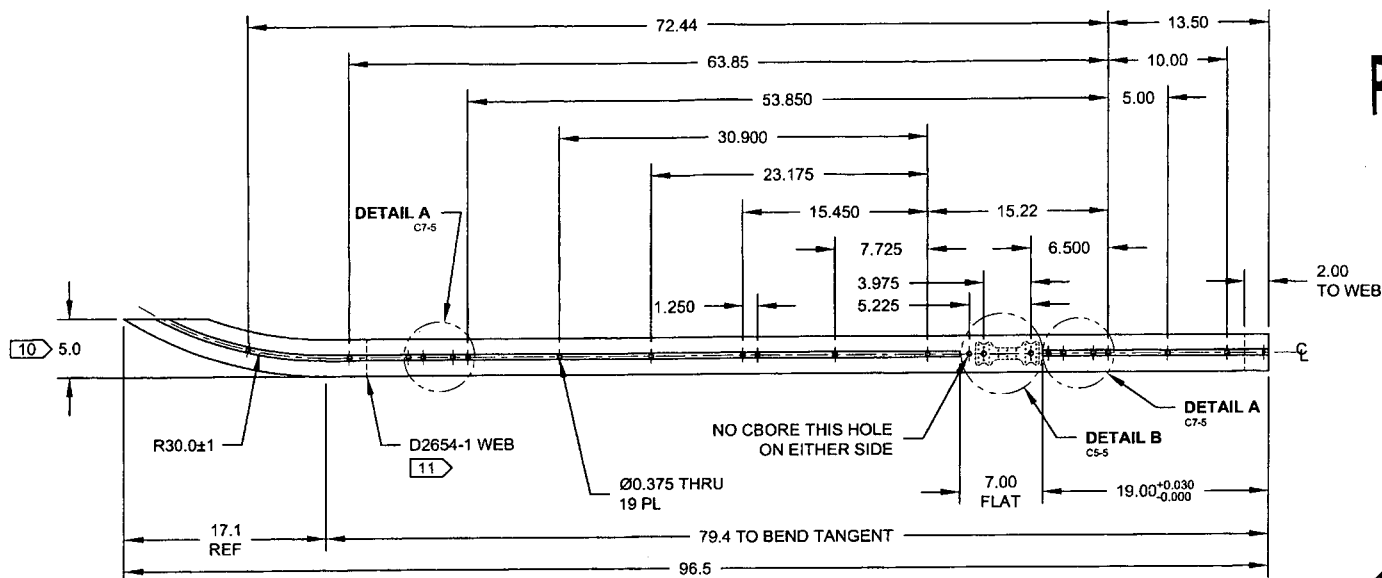
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

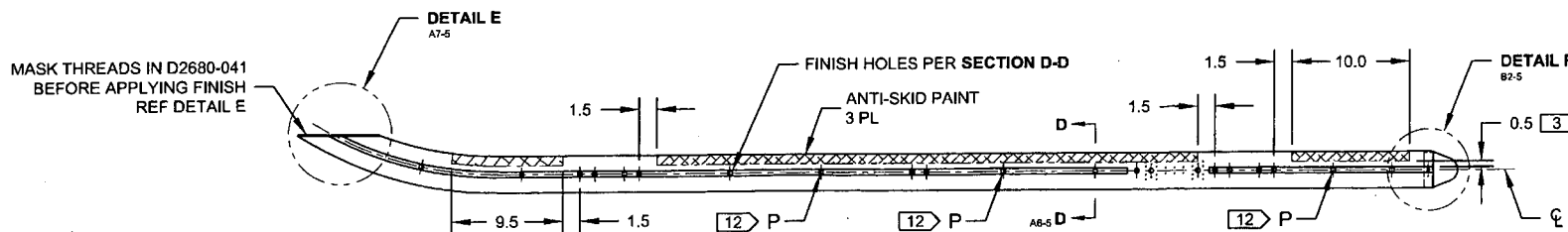
NOTE: Date & initial all entries

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL

15427



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 2 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

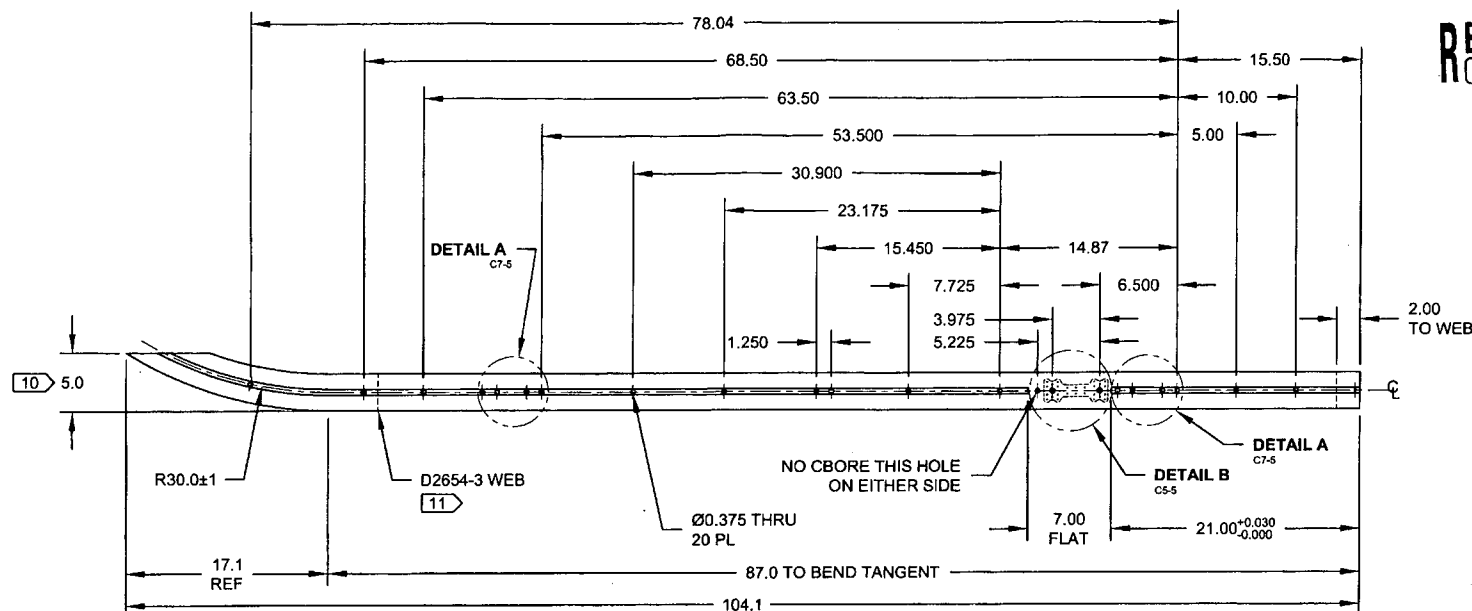
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

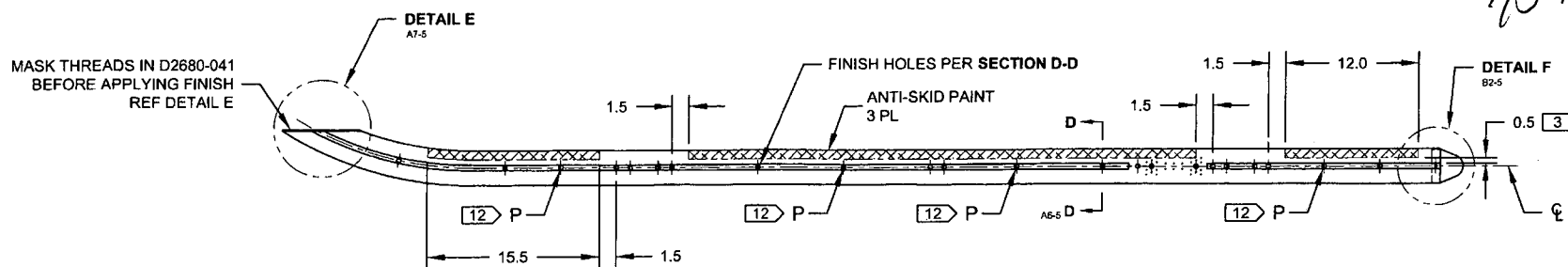
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
09.03.07



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

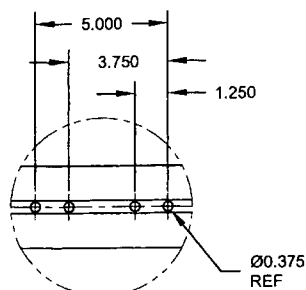
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

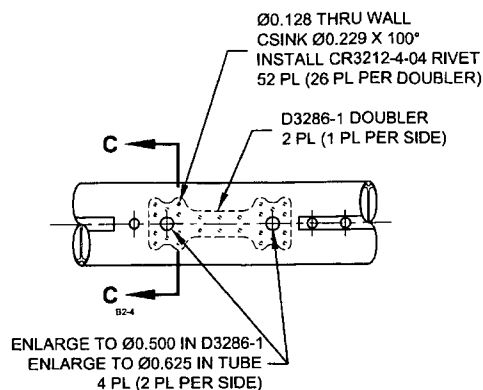
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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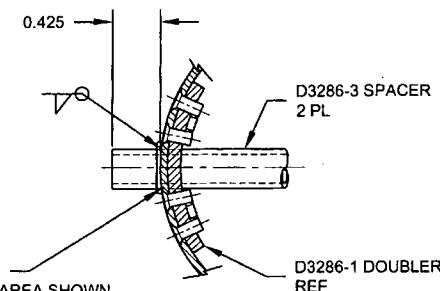
RELEASED
UP 09.03.03



DETAIL A D6-2
C2-2
D6-3
C2-3
SCALE NONE

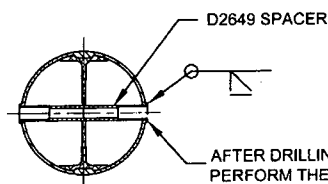


DETAIL B C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



SECTION D-D A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORER TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO. D3804	REV. A
MFG. APPR.	97	SHEET 4 OF 5	
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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75427

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07 07 07

CCR264SS3-3
RIVET
2 PL

CR3212-4-03 RIVET
2 PL

VIEW G-G
SCALE NONE A7-5

D2647 CAP, TO INSTALL:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS REQD)
4. WELD D2647 IN PLACE
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE
IN PLACE

MS27039-4-06 SCREW
AN960JD416 WASHER

D2680-041
NUTPLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

1/16

DETAIL E
SCALE NONE B7-2
B7-3

0.400

END OF WEB

SEAL WITH
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204
REF

MS27039-1-08 SCREW
AN960JD10L WASHER
2 PL

BORE OUT END
OF SKIDTUBE
TO 0.75 DEPTH
AND 0.070 WALL

DETAIL F
SCALE NONE B2-2
B2-3

72427

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 5 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries